

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018353**Date Inspected:** 30-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower / OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector,Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

Bay #11

This QA Inspector observed the following work in progress

ORTHOTROPIC BOX GIRDER (OBG)**Shielded Metal Arc Welding (SMAW)**

Weld joint # 014 located on Hole plugging in Bike path BK004A-022. Welder is identified as 037840. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112 -Plug.

Repair welding of Weld joint # 002 located on Bike path BK004A5-019. Welder is identified as 040655. ZPMC Quality Control (QC) Inspector is identified as Shao Hai Lang. The welding variables recorded by QC appeared to comply with the WPS – 345 –SMAW -1G (1F) -Repair.

Flux Cored Arc Welding (FCAW)

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Weld joint # 002 located on Bike path BK004A2-022. Welder is identified as 205649. ZPMC Quality Control (QC) Inspector is identified as Wang Chuang Xin. The welding variables recorded by QC appeared to comply with the WPS – B – T - 2132.

Tower

Shielded Metal Arc Welding (SMAW)

Weld joint # 74 located on West Tower, Lift4, 119 mtr., Skin B, Façade splice plate WSD1-FBSA4-2A/C. Welder is identified as 202323. ZPMC Quality Control (QC) Inspector is identified as Zhao Chen Sun. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2112.

Repair of Weld joint # 6A/B as per Welding repair report no. T –WR -3776, located on Lift 5 Bracket SD1 –BRSA5-1 . Welder is identified as 046769. ZPMC Quality Control (QC) Inspector is identified as Li Bin. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW -2G (2F) – Repair.

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as Bike path -OBG Component. The component and weld designation identified as follows:

BK004A5-019 –075, 076, 23

Bay #10

This QA Inspector observed the following work in progress

Tower

Shielded Metal Arc Welding (SMAW)

Weld joint # 5, 6 located on Façade plate built up assembly SD1 –SFSA4 -85. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

Weld joint # 11 located on Façade plate built up assembly SD1 –SFSA4 -324A/B -10. Welder is identified as 040581. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2114.

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Weld joint # 3, 4 located on Façade plate Pad eye ND1-SFSA4-710-3. Welder is identified as 050038. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112 -Padeye.

Flux Cored Arc Welding (FCAW)

Weld joint # 1, 2 located on Lift 6 Skin plate to stiffener SSD1-FBSA6 -1. Welder is identified as 040367 / 040458. ZPMC Quality Control (QC) Inspector is identified as Dong Zhi Bing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Weld joint # 9, 10 located on Façade plate built up assembly SD1 –SFSA4 -85. Welder is identified as 057266. ZPMC Quality Control (QC) Inspector is identified as Jiang Xiao Bo. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

Witness of Magnetic Particle Testing (MT)

This QA inspector Witnessed 100% MT performed by ZPMC Quality Control personnel. The member is identified as Façade plate Padeye and edgeplate joint -Tower Component. The component and weld designation identified as follows:

ND1 –SFSA4 -710 -14 (weld joint)

ND1 –SFSA4 -710 -2 (Pad eye joint)

For further information see below pictures:-

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

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Summary of Conversations:

No relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Hu (15002048250), who represents the Office of Structural Materials for your project.

Inspected By: Baskar, Govindarajan

Quality Assurance Inspector

Reviewed By: Clifford, William

QA Reviewer